

Date: Tuesday, 4/16/2006 9:59:40 AM
User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
Job Number : 26647 **B**
Estimate Number : 10337
P.O. Number : **NIA**
This Issue : 4/18/2006 S.O. No. : **N/A**
Prsht Rev. : NC
First Issue : **NIA** Type : MACHINED PARTS
Previous Run : 26625
Written By : **SEE COMMENT BELOW**
Checked & Approved By : **JA 06/04/18**
Comment : Est A 05.06.02 New Issue KJ/JLM

Part Number : D28073
Drawing Number : D2807 REV C
Project Number : N/A
Drawing Revision : C
Material : **NIA**
Due Date : 4/30/2006 Qty: **4** Um: **60** Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 6.5646 f(s)
Material: 303 Round Bar Ø0.750"
(M303R0.750)

M100806

Batch: **06/05/26**

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE
Turn as per Folio FA529 and Dwg D2807 Dwg Rev: **C**

2-Deburr

MS 06/05/27 4 60

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/05/27 4 60

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1
Machine as per Folio FA528 and Dwg D2807 Dwg Rev: **N/A**
Folio Rev: **N/A**

Machined Manually

2-Deburr

06/06/13 4

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/06/13 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, 4/18/2006 9:58:40 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26647

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

86 06.06.13

4

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A

SAN 06.06.13

4

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06.06.14

4

Job Completion



U Dec 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

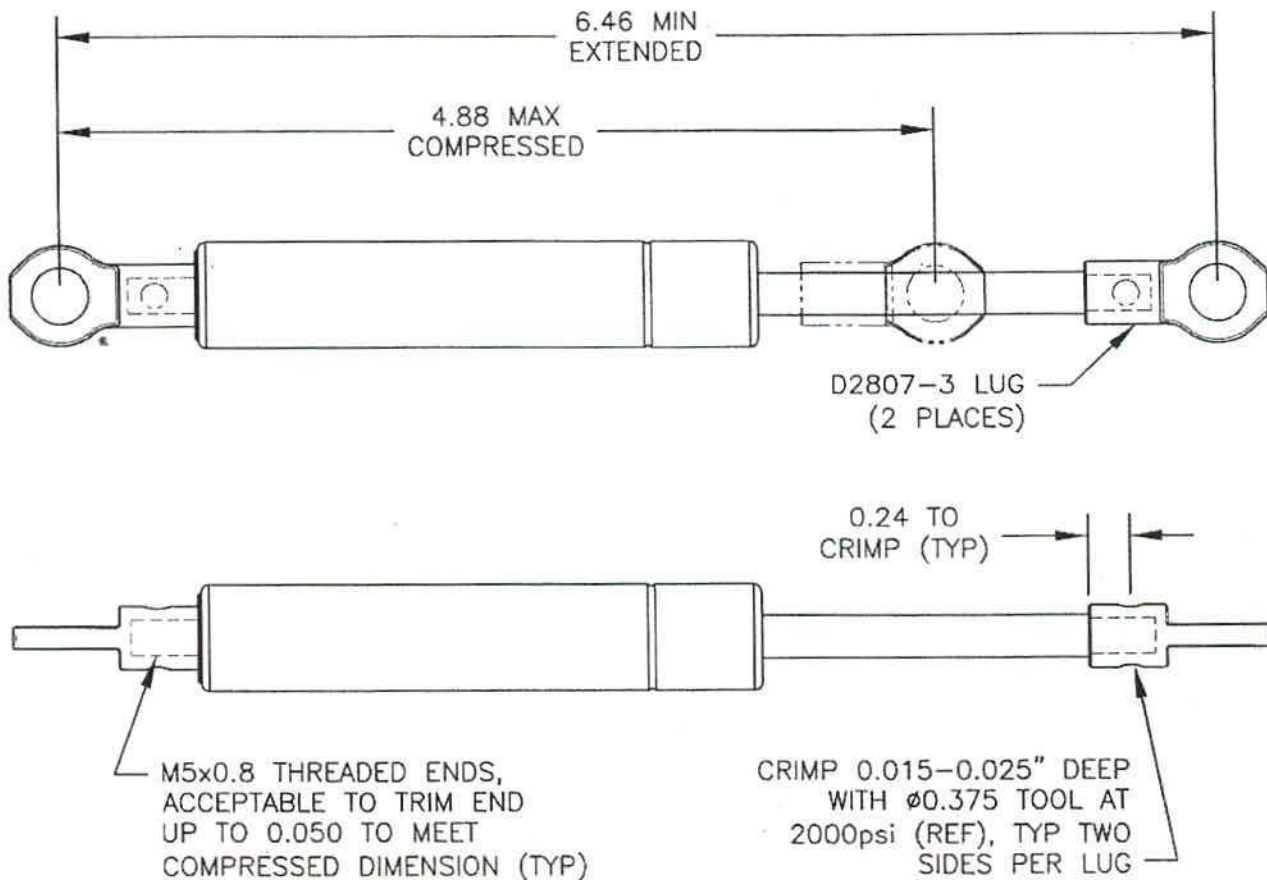
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
#65-06-16



D2807 GAS SPRING

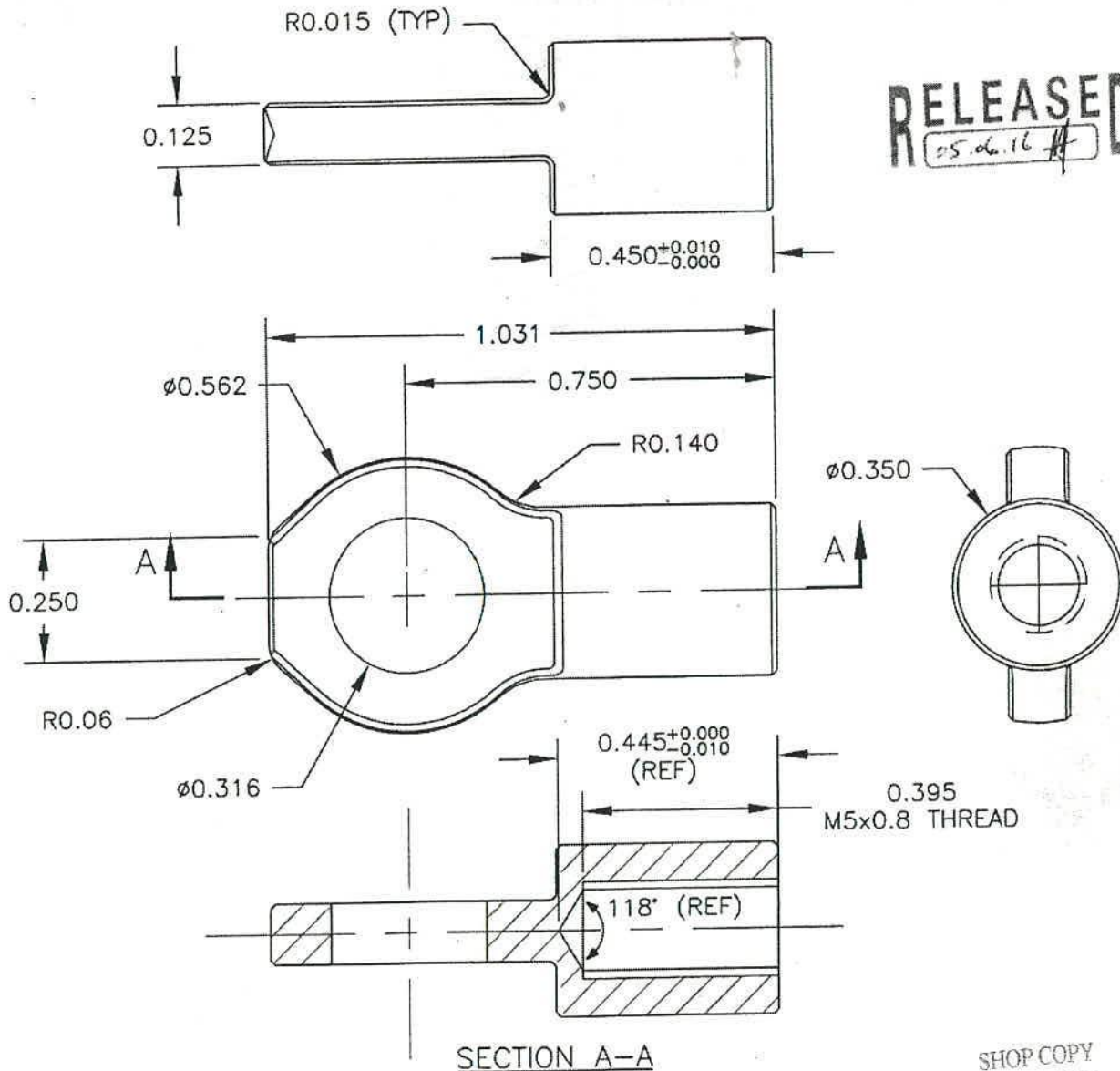
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS
- SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE	TITLE	REV. C
05.05.25	GAS SPRING	SHEET 1 OF 2
		SCALE
		1:1
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG

NO. 2647
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
REVIEW TO
SHIP COPY
POSSIBLE SUPPLIER

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**RELEASED**
05.06.16 H**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 26647

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